

Work Order ID 66218

February 7, 2011 2:29:52 PM



Page 1

Item ID: D4185-15

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Shaft

Start Date: 2/07/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: C2 Date: 11/02/07 Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4185	<u>PAS</u> <u>PA 7</u> <u>11.03.01</u>

100	MORI SEIKI CNC LATHE LARGE	0.00
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Doosan	Memo	0.00
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Doosan Lathe

TURN AS PER DWG AND FOLIO FB036
DWG REV: PAG
FOLIO REV: N/A

2-DEBURR

SA 11/3/3

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	-----------------------------------------	------

QC	Memo	0.00
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Quality Control

SA 11/3/3



MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 66218

Parent Item: D4185-15

Parent Item Name: Shaft



Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-01-29 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304R1.000

Purchased

No

100

f

73.7800

0.21

0.442105



304 round bar 1.00



SA 11/3/13

750

Location

Loc Qty

Loc Code

MAT029

73.78

109508

9.8

109541

15.31

116457

48.67

116501

42 R

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

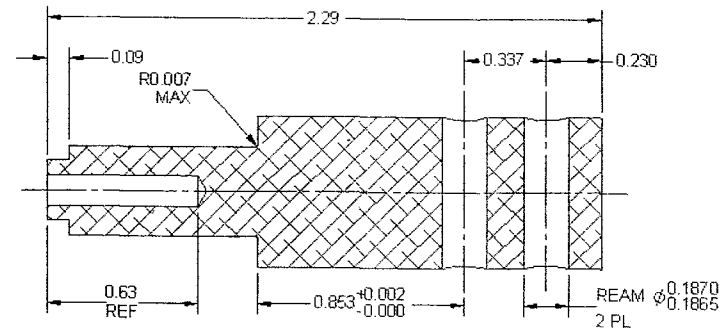
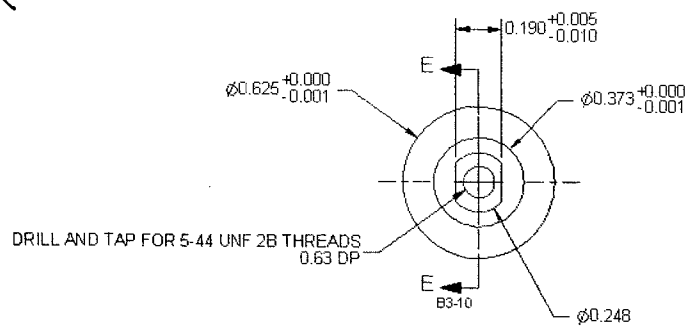
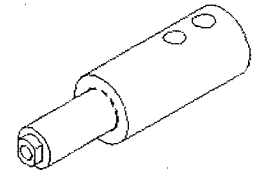
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

u/p 662/8







SECTION E-E

D4185-15 SHAFT

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER ASTM A276
REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAMMESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA7
MFG. APPR.		D4185	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		INTERNAL BELLCRANK	NTS
DATE	10.11.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE ON THE INTERNET WITHOUT FURTHER NOTICE			

Receiving Report

Date: 10/12/22
 Supplier: MAGNA

Batch No: M116501
 Dart P/O: 13157

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☒ N/A ☐
 Waybill Attached: Yes ☐ No ☒ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection 10/17/22 ☒ N/A ☒
 Work Order 10/17/22

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin: 10/12/22
 Date
 Received/Costing
 Initial

Location

VIRAJ PROFILES LIMITED

VIRAJ®

5

Unit-V
Survey NO 114, 119 & 120
Village Mahagoan
Dist: THANE 401 506
MAHARASHTRA, INDIA

TEST CERTIFICATE

ORDER NO	PACKING LIST NO	INSPECTION NO	DATE
P00984	IMP/910036/4	100000465829	05.03.2010
		GRADE	HEAT No
		304/304L	19791

BUNDLE NO :
5172844, 5172845, 5172846, 5172847,

DESCRIPTION

STAINLESS STEEL BRIGHT BARS

COLD DRAWN GROUND & POLISHED

SIZE	SHAPE	TOLERANCE	LENGTH	PIECES	WEIGHT
3/4"	ROUND	ASTM A484	12' - 14'	229	4,186.000 LB

CHEMICAL ANALYSIS

%C	%Mn	%Si	%S	%P	%Cr	%Ni	%Cu	%Mo	%Co	%N2
0.0200	1.660	0.430	0.0200	0.0360	18.360	8.020	0.560	0.330	0.130	0.07400

TEST RESULTS

0.2% yield strength ksi	Tensile Strength ksi	Elongation %	Reduction Of Area %	Hardness BHN	Grain Size NOS
88.0	107.0	45.0	70.0	219.0	7.0

SPECIFICATION:

MATERIAL CONFIRMS TO DIN EN 10088-3:2005:WNR 1.4301/1.4307 EN 10222-5 AND EN 10272 COND-A & ASTM A182/A-182M-06, A276-06 COND A, A479/A479M-06a COND A, A193/A193M-06a B8 CL-1, A320/A320M-05a B8 CL-1, A484 06b, A398/A398M-05, ASME SA182-04, SA479-04, SA193-04 B8 CL-1, SA320-04 B8 CL-1, ASTM A314-2002. IGC SATISFACTORY AS PER ASTM A 262-02a PRACTICE E. AMS 5639Q /AMS5647H (EXCEPT MARKING), QQ-S-763F, NACE-MR0175-2002. SAE-AMS-S-7720A, MIL-S-862-B, AISI 304/304L & UNS/S30400/S30403. CERTIFICATION AS PER EN 10204.3.1.

REMARKS

MATERIAL IS FREE FROM MERCURY CONTAMINATION, FREE FROM WELD OR WELD REPAIRS, MICRO: FREE FROM CONTINUOUS CARBIDE NETWORK ON GRAIN BOUNDARIES, MACRO: GOOD, MINIMUM SOLUTION ANNEALING TEMPERATURE 1050°C, SOAKING TIME 1/2 HR. WATER QUENCHED. MELT SOURCE: AOD. WE CONFIRM THAT THE MATERIAL HAS BEEN TESTED AND FOUND TO BE FREE FROM RADIOACTIVE CONTAMINATION. COUNTRY OF ORIGIN: INDIA.

We hereby certify that the material described above has been tested and complies with the terms of order/contract.

Suvarna

WORKS INSPECTOR
S. SUVARNA.

CS182

P010000-19791

10/12/22



Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



PACKING LIST

Page 1 of 1

1036925

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

SPECIAL INSTRUCTIONS

***STOCK

Contact: C.LAVOIE

Ship Terms: PREPAID

MTR:Y

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO#	
CANADIAN DOLLARS		DAVE MC VETY	(613) 632-5200	(613) 632-1053	13157	
Sales Order	Terms		Ship Via	Date Ordered	Date Required	Date Shipped
W040552	NET 30 DAYS		NIR:R-557065-1	12/21/10	12/22/10	12/22/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
4		PC	STAINLESS ROUNDS SRB 304 3/4" x R/L 12' 71 LB / 4 PC <i>P 16/12/22</i>	L039096	19791	4
Bundles: 1				Approx Weight	71 LB	

Received by: _____

Date: _____

Signature: _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO13157**

Purchase Order Date 12/17/10

PO Print Date 12/17/10

Page Number 1 of 1

Order From :

VC-MAG002

MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

Contact Name

Vendor Phone

800 363 6646

Vendor Fax

514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
12/17/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M304RO.750	304 SS Roundbar .750	12/20/10 Yes	48.00 f	Yours ppd	\$9.5000	\$456.00

Special Inst: MATERIAL: 304/316 SS ROUND BAR AS
PER ASTM A276
NOTE: 303 NOT ACCEPTABLE

PO Total:

\$456.00

P. 12/17/10

MATERIAL CERTIFICATION
REQD UPON DELIVERY

Change Nbr: 1

Change Date: 12/17/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Chantal Lavoie

From: Christina Antoniou [cantoniou@magnastainless.com]
Sent: December 16, 2010 11:38 AM
To: Chantal Lavoie
Subject: RE: quote

Hello Chantal,

Please see below

Thanks

Christina Antoniou
Magna Inoxydable et Aluminium
ventes internes aérospatiale/inside sales aerospace
5775 rue Kieran
St Laurent QC, H4S 0A3
Tel: (514) 339-1211 Fax: (514)339-1105
www.magnastainless.com

From: Chantal Lavoie [mailto:clavoie@dartaero.com]
Sent: December 15, 2010 1:04 PM
To: Christina Antoniou
Subject: quote

Hi Christina,
Please advise price & delivery on material.

304 round bar .750" x 48 ft \$ 114.00/EACH Stock Montreal
304 square tubing .750" x .750" x .049 " wall x 120 ft no stock at this time *regret

Thanks
Chantal

TRANSMISSION VERIFICATION REPORT

TIME : 12/17/2010 11:42
NAME :
FAX :
TEL :
SER.# : F9N212739

DATE, TIME	12/17 11:41
FAX NO./NAME	15143391105
DURATION	00:00:18
PAGE(S)	01
RESULT	OK
MODE	STANDARD
	ECM